Date: User:

Friday, 25/07/2008 4:20:49 PM

Julie Lecoca

Process Sheet

Customer

Written By

: CU-DAR001 Dart Helicopters Services

Job Number Estimate Number

: 40761 : 13507

P.O. Number

This Issue

: 25/07/2008

: NC

Prsht Rev.

First Issue **Previous Run**

: //

S.O. No. :

: SMALL /MED FAB

Type

Part Number Drawing Number Project Number

Drawing Name

: D2195 REV C : C

: BRACKET

: D21952

Drawing Revision

Material

: 20/08/2008 **Due Date**

Qty:

2 Um:

Each

Checked & Approved By

Comment

: Est Rev:A

08-07-24 new issue ec verified by:dd

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M304S16GA

304/316 Sheet .063



Comment: Qty.:

0.2216 sf(s)/Unit Total:

0.4431 sf(s)

304 SS Sheet 0.063" thick

batch: (08 724

B8-8-21

2.0

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2195

Dwg Rev:_ Prog Rev:__ B 8-8-21

2-Deburr if necessary

3.0

INSPECT PARTS AS THEY COME OFF MACHINE



H38-8-21



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK



BRAKE NC



5.0

NC BRAKE



Comment: NC BRAKE

Bend as per dwg D2195

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									;	
									:	
Part No	:	PAR #:	Fault Categ	ory:	NCF	R: Yes	No DQ	A:	_ Date: _	
						QA: N	/C Close	d:	Date:	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR	<u>(</u>)			
DATE	0750	Description of NC			ction B		Verific	cation [.]	Annroval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	n Approval Chief Eng	QC Inspector

NOTE: Date & initial all entries

Date: 1

Friday, 25/07/2008 4:20:49 PM

User:

Julie Lecocq

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40761

Part Number: D21952

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Process Sheet



7.0

PACKAGING 1

PACKAGING RESOURCE #1



Identify wiith Dart part # using a fine point permanent marker and Stock

Location: 18

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



108/08/26 U 08/08/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								:		
				•						

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

	•	WORK ORD	ER NON-CONFORMAN	CE (NCR)							
	Description of NC		Corrective Action Section B								
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
						!					
	7										
						!					
						<u>'</u>					
						j					
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Action Description Chief Eng	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Initial Chief Eng Chief	STEP Section A Initial Chief Eng Chief Eng Sign & Date Section C	STEP Description of NC Corrective Action Section B Verification Section C Chief Eng Chi				

NOTE: Date & initial all entries

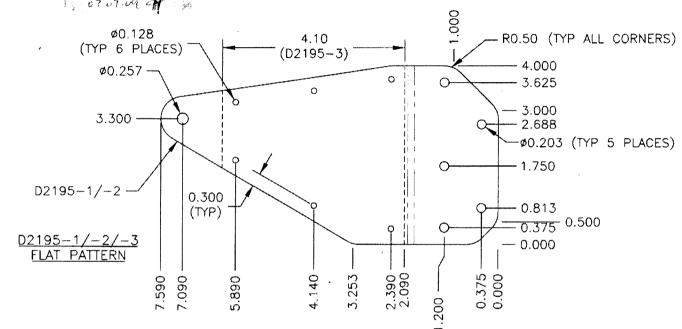


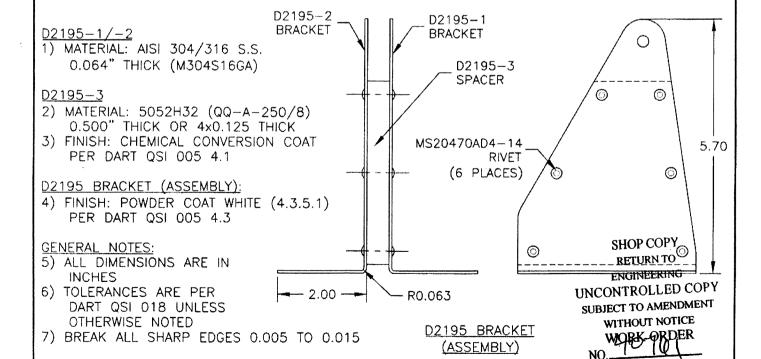


	DESIGN	DRAWN BY		AEROSPACE LTD KESBURY, ONTARIO, CANADA	************
f	CHECKED	APPROVED	DRAWING NO.	RE	V. C
	-#	9	D2195	SHEET 1 (OF 1
	DATE		TITLE	SC	CALE
	03.05.2	28	BRACKET		1:2
	R	93.09.23	RF-DESIGN	:	

1, 07 07 09 4

B 93.09.23 RE-DESIGN
C 03.05.28 REDRAW; D2195-3 NOW 0.5" THICK





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-DART-AEROSPACE LTD	Work Order:	40761	
Description: RRACLET	Part Number:	4 mg = D	2/25
BKROZE (1 die Idamious	UATTU IX	- 25 6
Inspection Dwg: りかんとう Rev: て		Page 1 of 1	ļ

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
861. X	100 200. 4	,130	x			
8.303	4.000001	306	×			
Ø .257	+ .066 - 001	259	×			
375	100	1375	×			
,813	4- 010	.816	*			
1.750	14/2 .010	1.754	*		<u> </u>	
2,688	4/010	2.690	×			
3,675	4/ DIO	3.631	¥			
4,000	4/ .010	4.007	×			
.375	4.00	375	*			
1.700	1- 010	1.199	X			
5.390	·/00	2,390	\varkappa			
4.140	4/010	4.143	*			
5.390	t/010	5,894	K			
7.090	4010	7.092	¥			
7.590	1/010	7,593	¥			
1063	1/2 1010	1059	×			
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Measured by:	iB	Audited by:	8	Prototype Approval:	\mathcal{A}	
Date:	8-8-21	Date:	०४०६ थ।	Date:	<u> </u>	4

1	Rev	Date	Change	Revised by	Approved
	Α		New Issue	KJ/JLM	

